

Work Order ID 60073

June 24, 2010 9:04:04 AM



Page 1

Item ID: D3255-042
 Revision ID:
 Item Name: Access Panel Assembly

Accept



Setup Start



Stop



Start Date: 6/24/10 Start Qty: 4.00
 Required Date: 7/02/10 Req'd Qty: 4.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan:
 QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start



Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3255 | Rev B |

100



Large Fab

Large Fab

Large Fab

Memo

1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD
 Batch: 1100715 12-Grind Welds Flush

0.00

0.00

② PD 10.07.12

110



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

8.06.12

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8.10.12

⑦2

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 60073

June 24, 2010 9:04:04 AM



Page 2

Item ID: D3255-042

Revision ID:

Item Name: Access Panel Assembly

Start Date: 6/24/10

Start Qty: 4.00

Required Date: 7/02/10

Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME: 2:20

OVEN TEMPERATURE:

320° FINISH TIME: 2:30

2:30

2 BL 10-7-12

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

8/10/07/20 ②

150



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255 IAR 736 DOW CORNING ADHESIVE
Batch: H11718

8/10/07/21 ②

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60073

June 24, 2010 9:04:05 AM



Page 3

Item ID: D3255-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.10/121

72

-042

170

Identify as per dwg & Stock Location: 176

0.00



Packaging

Memo

0.00

Packaging

10-7-22

S/P 22

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/23

MF

10-7-22

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:04:03 AM

Work Order ID: 60073

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly

Page 1



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-----------------|--------------|---------------|----------------|--------|
| D3255-2 Panel | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 4 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST183 | | | 4 | | | | | | |
| | | | | 48539 | | | 4 | | | | | | |
| D3255-3 Cap | | Manufactured | No | | | 150 | Each | 19.0000 | 1 | 4 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | WA | | | 19 | | | | | | |
| | | | | 48315 | | | 19 | | | | | | |
| D3255-5 Gasket | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 4 | | | |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | |
| | | | | ST047 | | | 8 | | | | | | |
| | | | | 48540 | | | 8 | | | | | | |
| | | | | | | | | | | | | | |

B 60 207

② 88 07/07/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DOA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

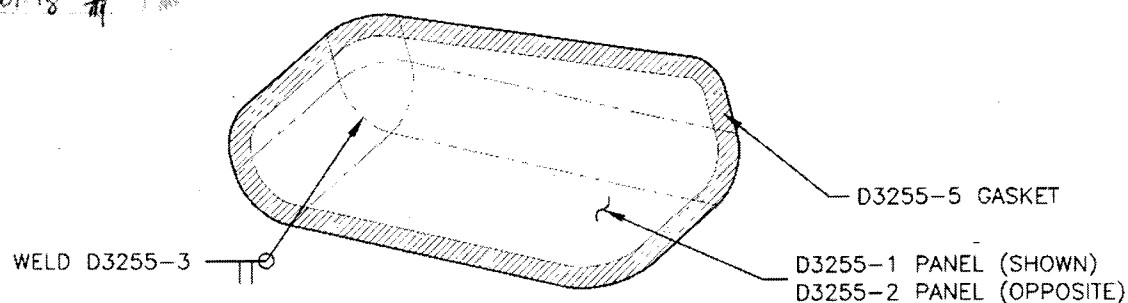
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

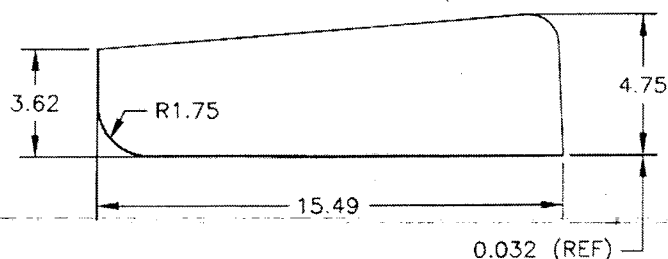
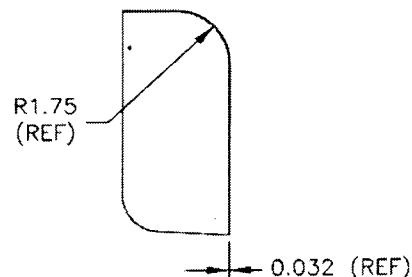
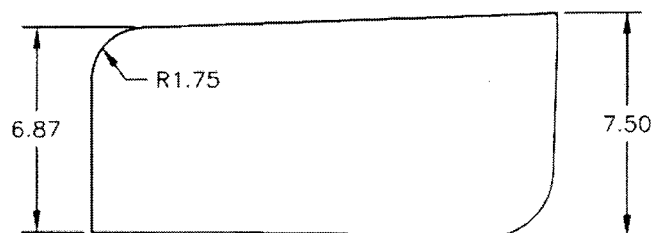


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|------------------|-------------------------|---|------------------------|
| DESIGN PA | DRAWN BY 1# | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED P | APPROVED [Signature] | DRAWING NO. D3255 | REV. B SHEET 1 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:6 |
| A | 04.01.27 | NEW ISSUE | |
| B | 04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098 | |

RELEASED
05-01-18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

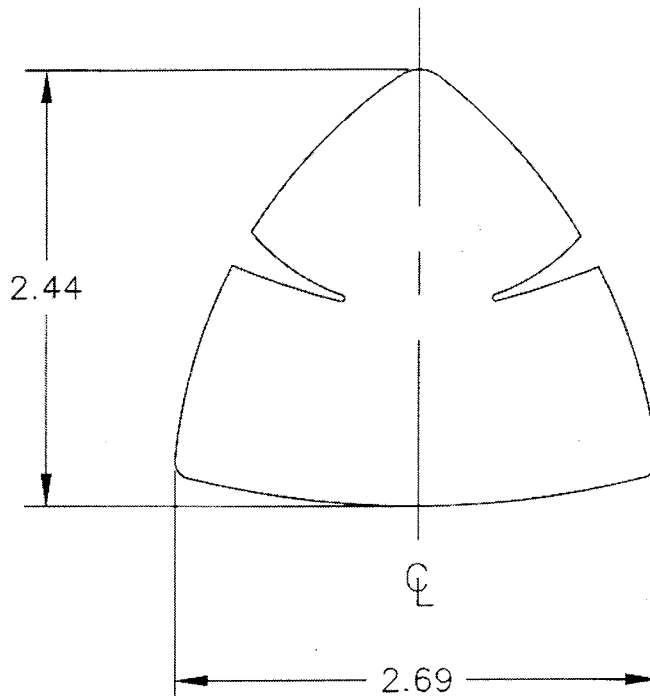
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| DESIGN JF | DRAWN BY JF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED JP | APPROVED [Signature] | DRAWING NO. D3255 | REV. B SHEET 2 OF 4 |
| DATE 04.12.06 | | TITLE TITLE | SCALE 1:1 |

RELEASED
05-01-08



D3255-3 CAP
FORM TO FIT D3155-1/-2

600073

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

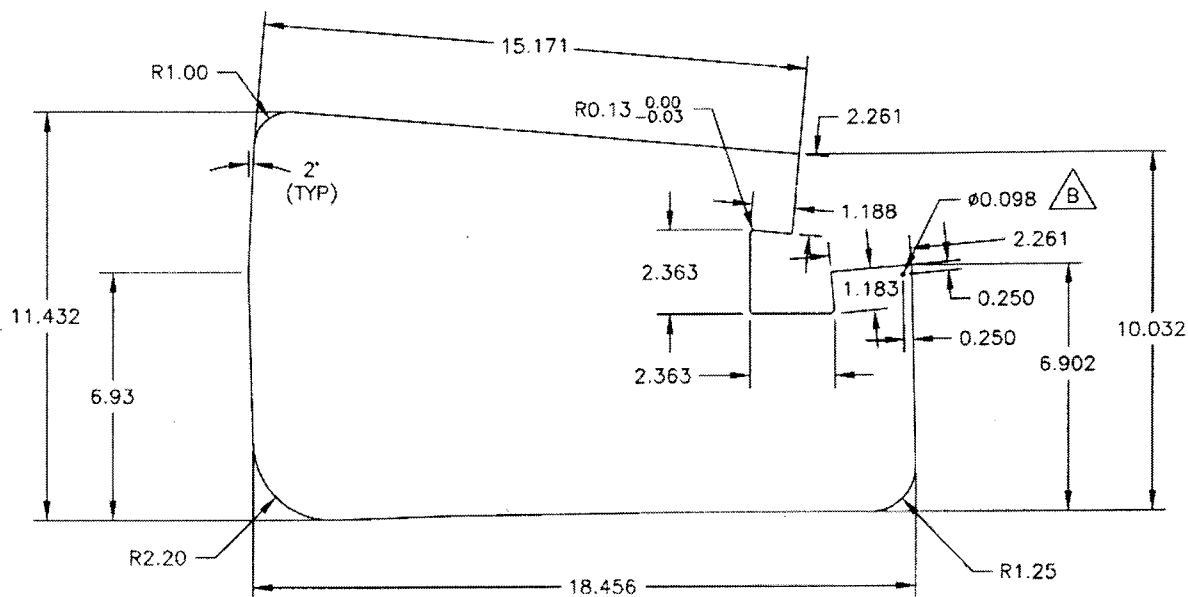
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| DESIGN D3255 | DRAWN BY D3255 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED D3255 | APPROVED D3255 | DRAWING NO. D3255 | REV. B SHEET 3 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

60023

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

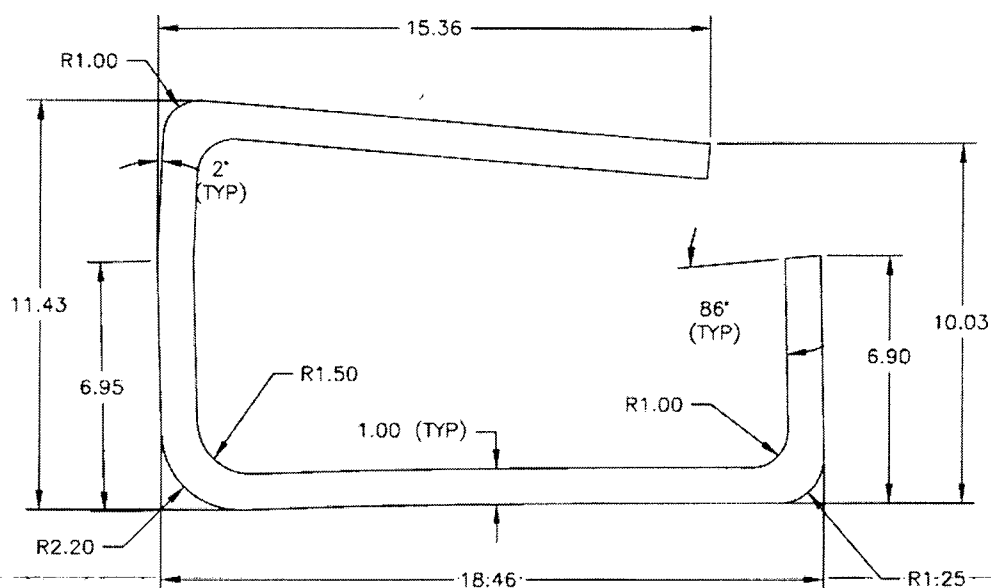
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| DESIGN 77 | DRAWN BY 77 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 47 | APPROVED # | DRAWING NO. D3255 | REV. B SHEET 4 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:5 |

RELEASED
DS 0118 #



D3255-5 GASKET

60073

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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